

Work Order ID 130522

130522

Page 1

Item ID: D4544-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Retainer, Center

Start Date: 3/13/2015 Start Qty: ~~800~~ ⁹

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 1503-13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4544	B								

115

0.00

115

Small Fab

Memo

0.00

Small Fab

FORM AS PER DWG USE DT9832
flat lenght 46.00"

9 FF MAR 16 2015

117

QC5- Inspect part completeness to step on W/O

0.00

117

QC

Memo

0.00

Quality Control

(9) DAS
38
9-89

MAR 23 2015

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

9 15-3-27
Doc

Work Order ID 130522

Friday, March 13, 2015 12:57:17 PM

130522

Page 2

Item ID: D4544-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Retainer, Center
 Start Date: 3/13/2015 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 3/13/2015 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									DAS
QC	Memo	0.00							38
Quality Control									MAR 27 2015
140	Identify as per dwg & Stock Location: <u>st 629</u>	0.00							
140									DAS
Packaging	Memo	0.00							27
Packaging									9
									MAR 30 2015
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									15/3/30

MS-3-30

Picklist Print

Friday, March 13, 2015 12:57:20 PM

Page 1

Work Order ID: 130522

130522

Parent Item: D4544-1

D4544-1

Parent Item Name: Retainer, Center

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP revA 12.01.17 new issue EC verified by:DD
REV:B 12.02.24 as per dwg reva DD verf:EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4544-3		Manufactured	No				f	4,869.000		31			

D4544-3

Extrusion

MAR 16 2015

Location

Loc Qty

Loc Code

MAT036

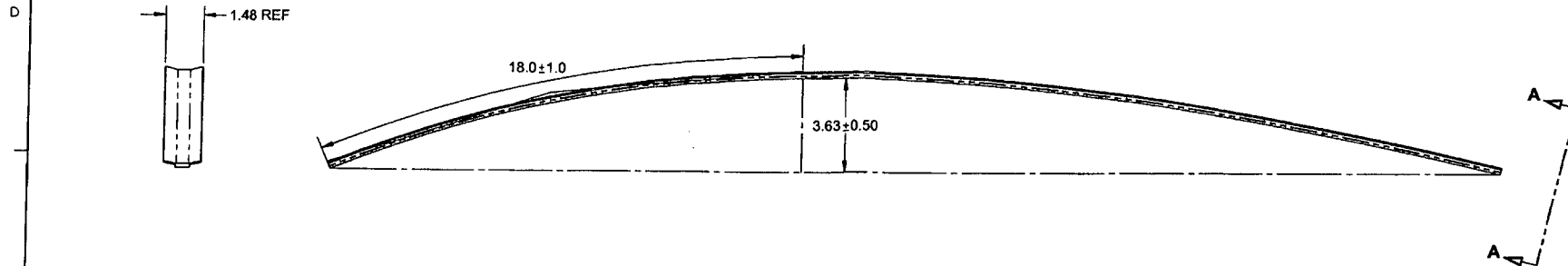
4869

86171

4869

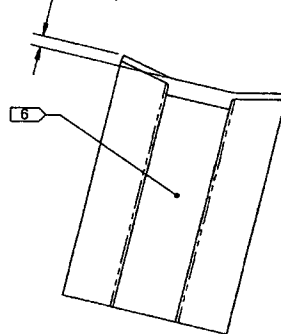
34.875

8 7 6 5 4 3 2 1



D4544-1 RETAINER, CENTER

FORM TO 0.10 TYP
(D4544-1F ONLY)



VIEW A-A
SCALE 4X
CROPPED VIEW

SEARCHED
SERIALIZED
INDEXED
FILED
130522 MJS
15-03-13

RELEASED
2012-05-07

NOTES:

- 1) MATERIAL: MAKE FROM D4544-1F OR D4544-3-460
FLAT LENGTH = 46.00"
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4544-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 0.61 lbs

B	ADD -1F (WAS -1); ADD -3; -1 NOW BENT AND FORMED. R0.031 WAS R0.015 (B6-2)	CP	12.04.20
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.04.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4544** REV. B
SHEET 1 OF 3
TITLE **RETAINER, CENTER** SCALE NTS

COPYRIGHT © 2012 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

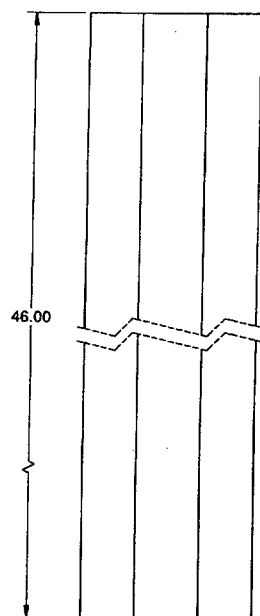
C

B

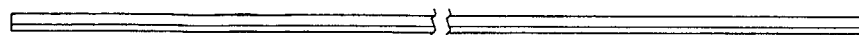
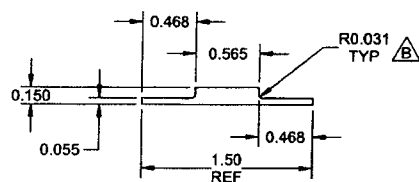
B

A

A



GRAIN
DIRECTION



D4544-1F RETAINER, CENTER

RELEASED
2012-05-03

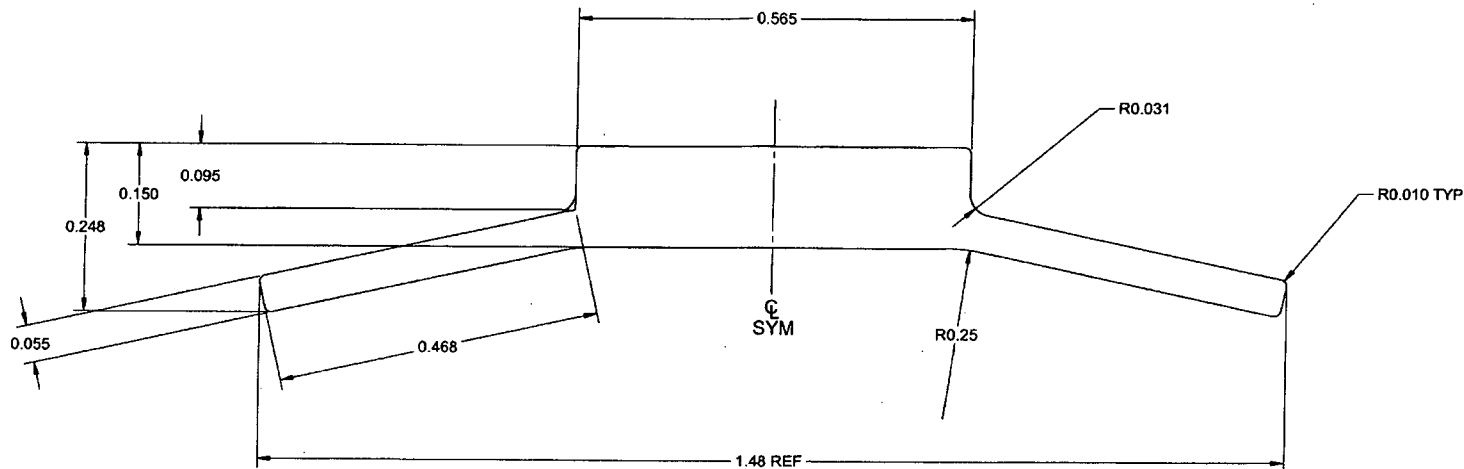
NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET OR BAR
 QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR QQ-A-250/11 OR AMS-QQ-A-250/11 (OR AMS 4025/4027)
 OR ASTM B211 OR ASTM B221 OR ASTM B209
 REF DART SPEC. M6061T6S OR M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.61 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4544	REV. B
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		RETAINER, CENTER	NTS
DATE	12.04.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

SPECIFICATION CONTROL DRAWING



D4544-3-XXX EXTRUSION

NOTES:

1) D4544-3-XXX EXTRUSION

LENGTH

WHERE 'XXX' IS LENGTH IN TENTHS OF AN INCH
EG. 46" LONG EXTRUSION = D4544-3-460

- 2) MATERIAL: 6061-T6 ALUMINUM EXTRUSION PER QQ-A-200/8 OR AMS-QQ-A-200/8 OR ASTM B221
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.0137 lb/in
- 8) NO TOOLING ID MARKS

DESIGN	<i>g</i>	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SS</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>g</i>	D4544	SHEET 3 OF 3
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	RETAINER, CENTER	NTS
DATE	12.04.20	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE BUSINESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2012-05-07
RELEASED
2012-05-07